

Work Order ID 109763

November-28-13 1:31:19 PM

109763

Page 1

Item ID: D2573

D 2573

B 109763

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Aft, Out

Start Date: 11/28/13 Start Qty: 12.00 *12*

Cust Item ID:

Required Date: 12/12/13 Req'd Qty: 12.00 *12*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 13-11-28 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2573	F
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100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 109763

Double check by: MM

DR/B.A.
13-12-14

12 ϕ

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

DR/B.A.
13-12-14

12 ϕ

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NG 13-12-3.

Hand Finishing

Work Order ID 109763

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109763

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Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft, Out
 Start Date: 11/28/13 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/12/13 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M126829</i> Memo START TIME: <i>8:55</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:25</i>	0.00 0.00				<i>12</i>	<i>0</i>	<i>14-1-8</i>	DAS 34 9-89
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>12</i>			DAS 27 9-89 <i>14/1/8</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>5T442</i> Memo	0.00 0.00				<i>12x</i>		<i>14-01-8</i>	DAS 28 9-89

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Item ID: D2573 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, Aft, Out
 Start Date: 11/28/13 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 12/12/13 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

14-01-8

03/01/2014
 14014

Picklist Print

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Page 1

Work Order ID: 109763

109763

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft, Out

Start Date: 11/28/13

Required Date: 12/12/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	57.0000	1	12			

D6101-007

**

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

9

103030

1

106883

8

MAT044

48

108537

8

108876

40

8

4

FA 13/12/07

DART AEROSPACE LTD	Work Order: 109763
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.001	8.003		
F	0.490	0.510		.501	.503	.501	.503		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.503	.505	.5025	.5015		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.571	.5685	.5685		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.124	4.124	4.124		
P	0.115	0.135		.126	.126	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.252	.249	.250		
S	0.115	0.135		.127	.125	.127	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.233	3.230		
V	0.230	0.250		.241	.243	.242	.240		
W	0.115	0.135		.123	.122	.131	.130		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.355	.358	.358	.358		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.629	.6285	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.246	.246	.251		
AE	1.500	1.520		1.512	1.513	1.512	1.513		
AF	0.115	0.135		.115	.115	.115	.115		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.251	.254	.252	.2515		
AI	2.000	2.020		2.002	2.004	2.002	2.003		
AJ	0.023	0.043		.033	.032	.033	.033		
Accept/Reject									

Measured by: 廖太
Date: 13/12/08

Audited by: [Signature]
Date: 13-12-30

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]

DART AEROSPACE LTD	Work Order:	109763
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5 A	6 A	7 A	8 A		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.002	8.0005	8.001		
F	0.490	0.510		.499	.499	.506	.506		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.5015	.5015	.5005	.5025		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.5675	.5665	.5665	.5705		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.123	4.123	4.124		
P	0.115	0.135		.124	.125	.126	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.252	.251	.251		
S	0.115	0.135		.125	.124	.124	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.230	3.236		
V	0.230	0.250		.239	.240	.240	.240		
W	0.115	0.135		.133	.133	.133	.130		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.361	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.629	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.256	.250		
AE	1.500	1.520		1.510	1.510	1.514	1.5125		
AF	0.115	0.135		.120	.120	.120	.120		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.2505	.2505	.250	.241		
AI	2.000	2.020		2.001	2.002	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: DP 2/B.C.	Audited by: [Signature]
Date: 13-12-11	Date: 13-12-30

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]

DART AEROSPACE LTD	Work Order: 109763
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

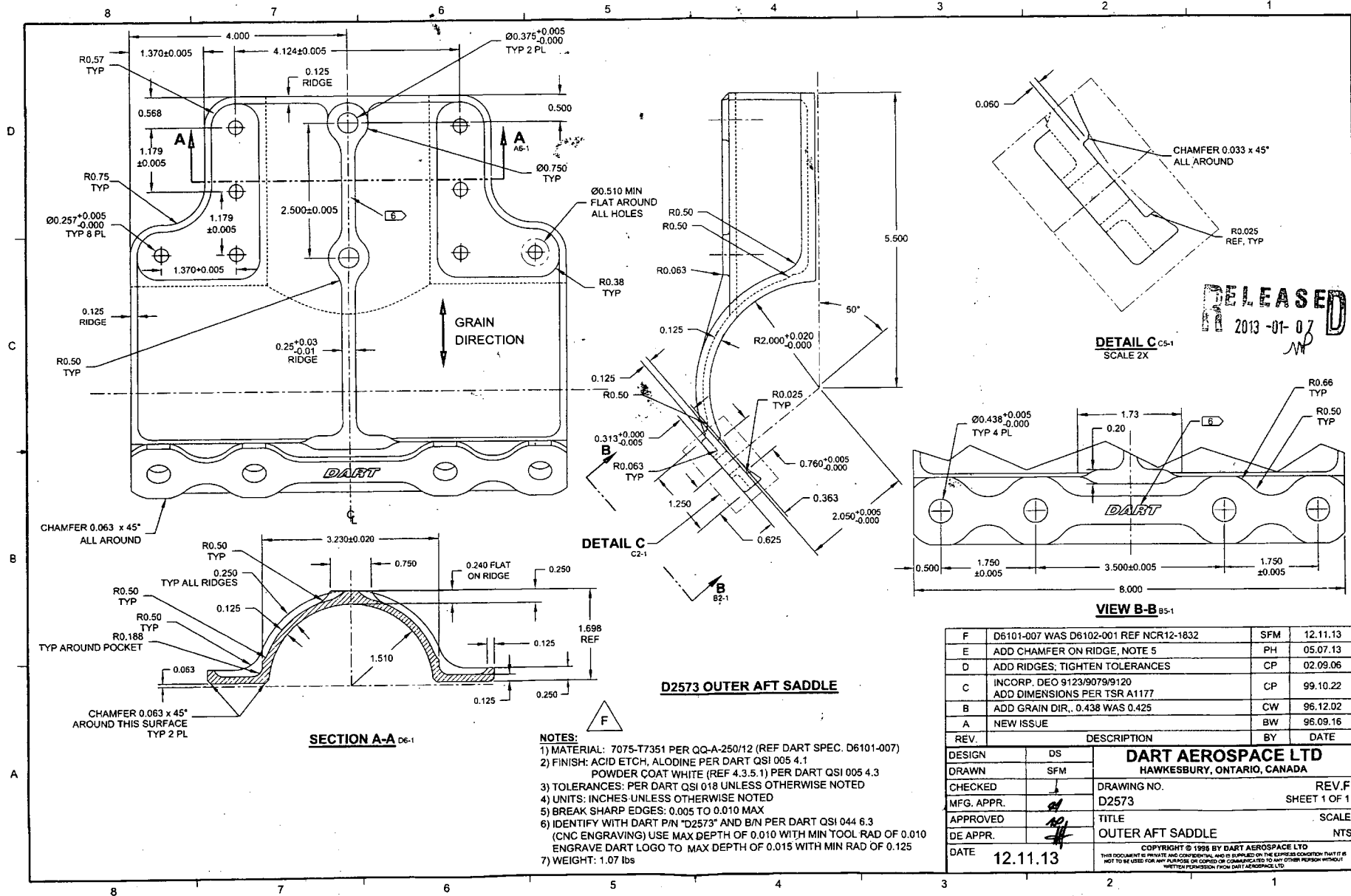
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 A	10 A	11 A	12 A	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.001	8.002		
F	0.490	0.510		.500	.499	.498	.498		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.4985	.499	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.568	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.124	.125	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.249	.250	.249		
S	0.115	0.135		.125	.124	.124	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.234	3.234	3.234	3.234		
V	0.230	0.250		.231	.235	.235	.235		
W	0.115	0.135		.131	.131	.131	.131		
X	0.308	0.313		.306	.306	.306	.306		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.361	.361	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.625	.625	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.51	1.51		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.275	.270	.271	.272		
AH	0.240	0.260		.247	.246	.246	.246		
AI	2.000	2.020		2.001	2.002	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 13-12-17

Audited by: <i>[Signature]</i>
Date: 13-12-30

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	<i>[Signature]</i>



F	D6101-007 WAS D6102-001 REF NCR12-1832	SFM	12.11.13
E	ADD CHAMFER ON RIDGE, NOTE 5	PH	05.07.13
D	ADD RIDGES; TIGHTEN TOLERANCES	CP	02.09.06
C	INCP. DEO 9123/9079/9120 ADD DIMENSIONS PER TSR A1177	CP	99.10.22
B	ADD GRAIN DIR., 0.438 WAS 0.425	CW	96.12.02
A	NEW ISSUE	BW	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV.F
MFG. APPR.		D2573	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		OUTER AFT SADDLE	NTS
DATE	12.11.13	<small>COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

10 9763 MLC
13-11-28